

ABSTRACT

A process for manufacturing ratchet wheels comprising the steps of preparing wax patterns of the finished product of ratchet wheels, stacking the wax patterns atop one another to form a pattern tree; dipping the tree-link pattern into a slurry and they drying the same so as to form a shell; breaking the shell when the molten metal solidifies so as to obtain cast products of the ratchet wheels; polishing and cleaning the cast products; processing the cast products with a CNC lathe to define two annular grooves on respective sidewalls of the cast products such that the same are made annular semi-products; and processing the semi-products by milling so as to define a plurality of teeth on respective sidewalls of the semi-products such that the same are made finished products.